

Work Order ID 139338

November 26, 2015 1:12:03 PM

139338

Page 1

Item ID: D212-725-1-949

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Duct Assembly

Start Date: 11/24/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/11/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

SW

Date: **20151130**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4065

C

100

0.00

DAS

100

HAND FINISHING THERMOFORMING

07

Thermoform

Memo

0.00

2

9-83

Thermoforming Machine

Cut Blanks

12/12/17

105

0.00

DAS

105

HandThermo

Memo

0.00

2

07

9-83

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Polycarbonate

12/12/17

Temp:

245 deg. F

DEC 16 2015

Time IN:

5:00 PM

Time OUT:

6:00 AM

Per.....*JK*.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 139338

139338

Page 2

November 26, 2015 1:12:03 PM

Item ID: D212-725-1-949

Accept

N900040100

Setup Start

NS1

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NS2

Item Name: Duct Assembly

Start Date: 11/24/2015 Start Qty: 2.00

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Cust Item ID:

Required Date: 1/11/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-83
110	THERMOFORMING MACHINE					2			15/12/17
Thermoform	Memo	0.03							
Thermoforming Machine	Thermoform D212-725-1-251 and D212-725-1-253 as per DT9581 and Dwg. D4065 and Work Instruction WI 071								
	Visual inspection for proper formation								
	Dwg. Rev. <u>C</u>								
	WI Rev. <u>C</u>								
130		0.00							DAS 07 9-83
130	HAND FINISHING THERMOFORMING					2	1		16/01/07.
Thermoform	Memo	0.02							PTO →
Thermoforming Machine	Trim Part D212-725-1-251 AND D212-725-1-253 parts for Assembly								

DQA:

Date:

16/01/15

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

16/01/11

Work Order update only ☐

Work Order: <u>139338</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D212-225-1-949</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5516</u>		Scrap ☒		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☒	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: <u>16/01/07</u>		Step #: <u>130.</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		DAS 9 9-89 16-01-07		Completed By	
Accidentally cut into part while hand hand trimming.		Scrap 1 part & Remake.				16/01/07	
R.C. Employee rushing.		B. M133903				Lead hand / Supervisor Approval Verification	
						16/01/07 16-01-07	
						QC / QA Coordinator Approval	
						DAS 9 9-89 16-01-07	
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☒	Heat Treat ☐	Cut Too Short ☒	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER: <u>undesired cut while hand trimming.</u>					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
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Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

MF
16-1-05

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Picklist Print

November 26, 2015 1:12:07 PM

Page 1

Work Order ID: 139338

139338

Parent Item: D212-725-1-949

D212-725-1-949

Parent Item Name: Duct Assembly

Start Date: 11/24/2015

Required Date: 1/11/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.09.14 NEW ISSUE DD VERF:EC
14/01/20 Change "Folio" to Work Instruction DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
EZ250150		Purchased	No				Each	0.0000		2			DAS 07 9-83
F7250150									**				
Adhesive, 3M Scotch Weld													
MLEXS.093-F6006-02		Purchased	No				sf	1,048.947		7.894737		16/01/07	DAS 07 9-83
MI FXS 093-F6006-02									**				
GE PLASTICS LEXAN SHEET													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				therm	1048.94737								
				m127208	1048.94737								
											11.85 sq ft.		

DQA: _____ Date: _____



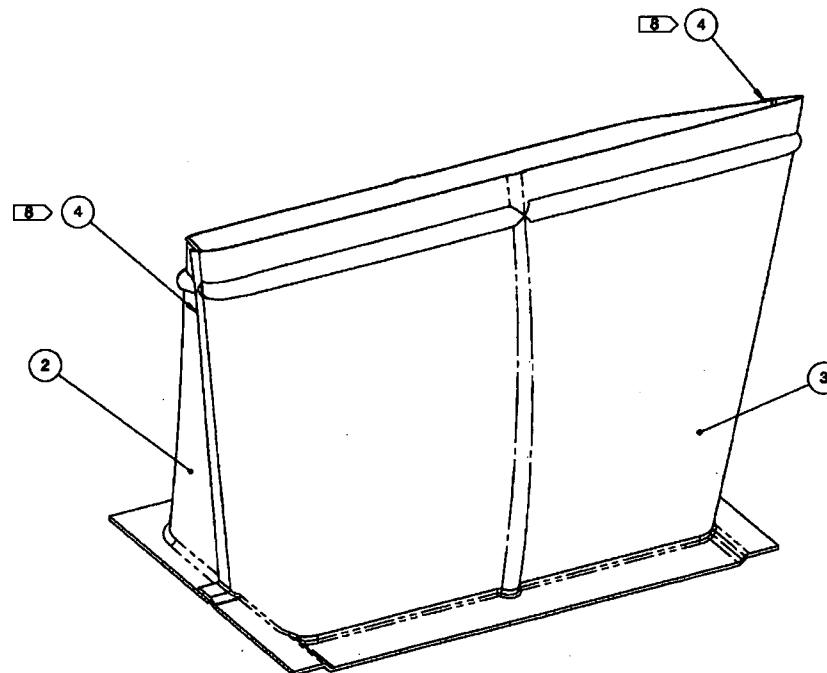
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
1	X	D212-725-1-949	DUCT ASSEMBLY
2	1	D212-725-1-251	FWD DUCT
3	1	D212-725-1-253	AFT DUCT
4	A/R	EZ250150	ADHESIVE, 3M SCOTCH WELD OR DEVCON PLASTIC WELDER II



D212-725-1-949 DUCT ASSEMBLY

RELEASED
2013-10-07

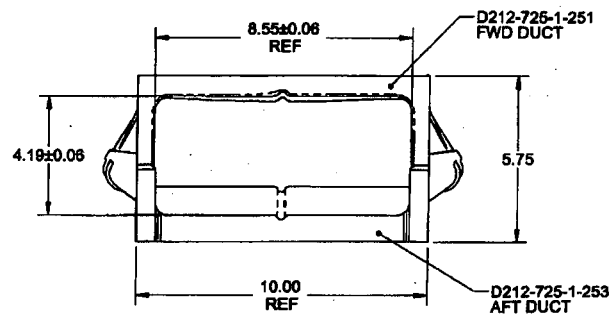
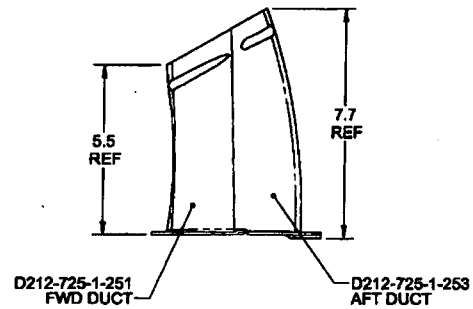
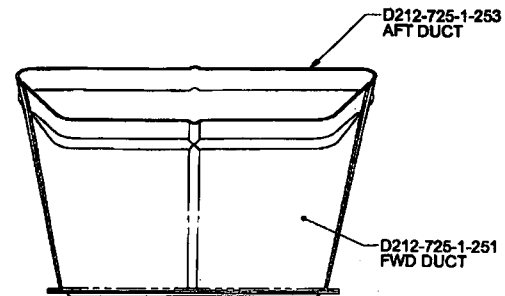
20151130

SH 139338

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.88 lbs
- 8) SEAL MATING EDGES WITH EZ250150 ADHESIVE OR DEVCON PLASTIC WELDER II ALONG MATING PERIMETER WITH MINIMUM THICKNESS OF 0.020"

C	REVISE NOTES TO ADD DEVCON PLASTIC WELDER II OPTION. REASON: SHOP REQUEST.	SFM	13.07.15
B	D212-725-1-949 WAS D4065-041 (ZN A4-1, D3-1, A4-2); D212-725-1-251 WAS D4065-1 (ZN A4-3, D3-1, C4-2); D212-725-1-253 WAS D4065-3 (ZN A4-4, D3-1, D4-2, B4-2, C1-2)	RF	11.02.24
A	NEW ISSUE	RF	10.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED	S	DRAWING NO.	REV. C
MFG. APPR.	RF	D4065	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DUCT ASSEMBLY	NTS
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